

Date: Thursday, 3/30/2006 1:25:05 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 26466		
Estimate Number	: 10699		
P.O. Number	: N/A	Part Number	: D3391025
This Issue	: 3/30/2006 S.O. No. : N/A	Drawing Number	: D3391 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 26465	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/6/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	1 Um: Each
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC : Est Rev: C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
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Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 24315 (D6014-104) MS 06/04/01 1

Identify as D3391-3

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: D

MS 06/04/01 1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/04/02 1

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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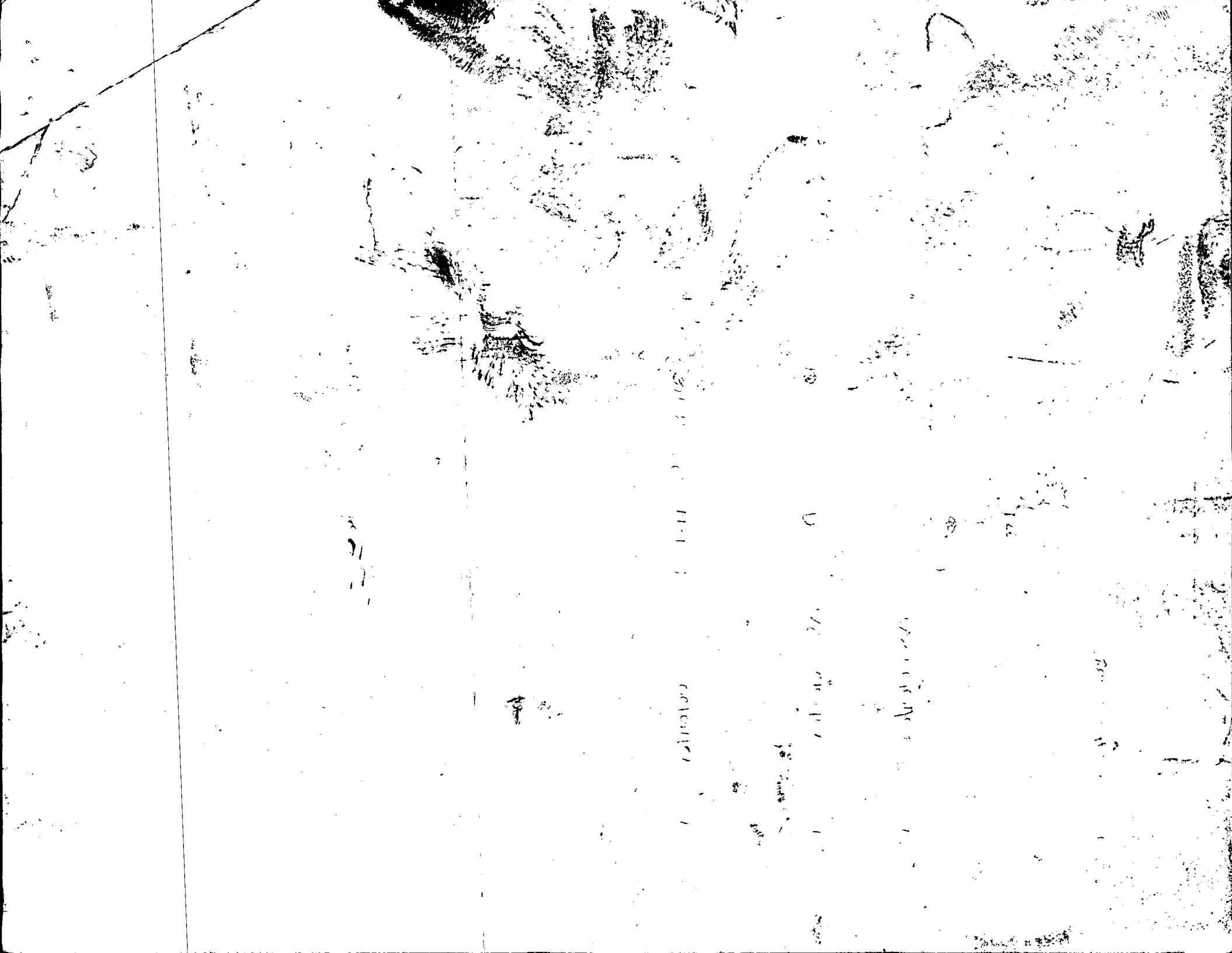
Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: D

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

BC 06/04/05 1



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Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BE 06-04-05

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/04/07

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP06-4-9

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-10

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

DP06-4-10

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

DP06-4-10

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

BE 06-4-11

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

BE 06-04-11

5-Deburr

BE 06-04-11

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-11

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

06-04-13

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Job Number: 26466

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

~~Q. m 06-04-25~~ (1)

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DC 06/04/26 (1)

14.0 AESS10KB366 INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

M17905 /

15.0 NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

M100732 /

16.0 AESS10KB266 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

M17905 /

or NAS1330C3KB266

17.0 AESS10KB316 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB316 Insert

M17905

or NAS1330C3KB316

DC 06/04/26 (1)

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	D2646	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B23370B ✓

19.0	AN3C4A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	M19522 ✓

20.0	AN960C10L	washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	M18822 ✓

21.0	NAS1515H3L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	M19185 ✓

DL 06/04/26 ①

22.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M100480

Sikaflex expiry date: 11/06

DL 06/04/26 ①

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Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 01/04/26

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24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

AL 06/05/01 02

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/02

①

Job Completion



U 06-05-02

